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XIV

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NEW YORK

together in a zig-zag. When the frame was taken from the jig were and formers were provided which pulled the struts into shape. There is much to be learned from experience against making open welding for tension struts and fabricators considered in the principle as far as the struts and impingers are concerned but failed it by welding on the formers in which the struts are attached.

The metal monocoque type of fuselage has several important advantages. A perfect structure shape can be produced as cheaply as an offset shape. The surface is not distorted by structural members and the necessary space is provided for passengers or freight. The method of construction

has local resistance. Another advantage of the metal loading gear has been mentioned before, its ability to withstand considerable deflection without fracture.

Metal and Fabric Covering

The choice between metal and fabric for covering wings has never been definitely settled. A fabric covering is properly protected against the rays of the sun by the use of painted dope with but at least a year or more anywhere except in the tropics. The thickness of the fabric which is a disadvantage to not weigh much more than dope fabric. The decision must be made on a case by case basis.



Details of fuselage construction. Fig. 3—Front portion of fuselage, showing wing root construction and front view. Fig. 4—Interior of fuselage. The corrugated structure makes the use of fuselage monocoque. Fig. 5—General view of the wing, showing corrugated structure covering and support form of wing.

cannot be quite simple. The metal monocoque fuselage if it is to be structurally efficient must be provided with closely spaced circumferential stiffeners which must stiffen not only the fuselage but may be produced at little expense. Localized stiffeners also add to the structural efficiency but add to the skin thickness and increase drag if placed outside. In the well designed fuselage the metal covering is mounted on formers to withstand the tension and shear while the stiffeners take the compression stresses.

Kind of Steel Fabric

The metallic steel fabric structure is undoubtedly the most satisfactory type which has been developed and is used extensively even with the wooden fuselages. All parts of the engine are easily accessible when the covering has been removed. The maintenance can be as simple as the engine power plant may be obtained by simply removing door bolts and disconnecting the engine cranks. The inserts for bolt heads at the front ends should be riveted and braced in place. The metal monocoque construction should not be expected to support the engine. Adequately braced and secured and the effect of vibration upon this steel metal should provide its use for strength members in the proximity of the engine. The monocoque construction may be non-monocoque supported at the wing root and should be placed just out of the main compartment.

The steel tube has been the standard material for sides from the very first. In most ways the development of the alloy seamless steel tube has enabled designers materially to reduce the weight. At present the steel tube is rapidly replacing the wood as the material for loading gear struts even on wooden airplanes. The ease with which tubes may be telescoped action does not constitute value this steel structure when placed either on the struts or inside the fuselage or wing. This arrangement makes it possible greatly to increase the displacement at the shock absorbers without reducing the ground clearance of the axle. This is particularly desirable on large machines where the rise of the wheels and axle may be noticeably reduced and the wheel landing gear lightened the amount of the necessary shock absorbers. The elimination of spools and shock absorbers at the attachment of the struts to the axle permits reducing the axle close up to the wheel and makes possible the use of a much lighter axle line in the wheel end as well. The wheel arrangement is much simpler than the old wooden landing gear and often

to replace two important structural elements, the ribs and the drag bracing. The metal covered wing generally presents difficulties in assembly due to the fact that the ribs must be backed up from the inside. A suitable compound to use is the Duxon C-10 in which the wing covering is riveted on from the outside. Each rib extends the rib, has flanged edges of the covering and a light channel which flanges the flanged edges and helps to hold them together. Light stiffeners on inside the covering bridge the space between the ribs and permit a wide rib spacing. In the fuselage wing the corrugated covering together with multiple splice channels the spacing for ribs. It is doubtful if this arrangement would replace ribs and wing in wood, however. The corrugated covering is about three times as heavy as dope fabric. The corrugated covering impairs the effectiveness of the covering as drag bracing. This metal rib can be made positively light was demonstrated by a recent fuselage rib with a 75 in. chord and which was a steel fabric of twelve with a weight of only 5 lb. as compared to 12 lb. for a similar rib of low strength.

Another advantage claimed for the metal covering is that it can be used to cover the wing frame in carrying their load. This advantage is not generally realized as the fuselage has been proved by tests with aluminum which were developed to prevent corrosion in a water plane. These efforts proved to be much more effective against water tested than those with aluminum with a surface flat plate riveted in place. It has become an axiom in metal construction that the flat plates are to be avoided whenever possible. Curves are in the same position. The flat plate is the worst of all. The flat depth of the wing section may be defined for beam depth in the metal covering tube is generally a more important consideration than the normal strength required for the covering. The covering acts in a great plate in over the skin stresses across the beam without the use of deep supports.

Very important consideration in the design of extremely broad wings is provision against torsional deflection. In a new design there is a strong tendency to cut the wing which is resisted by the tail. The tail must be able to reduce the angle of attack of the wing tip and thus increase the downward on the tip of the drag wing beam, thus increasing the stability. The most effective way of reducing the angle of attack is a drag wing in two parts, one near the wing root and one near the

tip. This makes the longer and drag lowering in effect, a rectangular tail. The principle of wing twist is the deflection of the wings covered wing where the covering makes the beam in carrying the load, forms the drag bracing and helps to distribute the load between the wing beams by resisting torsional deflection. An excellent example of this type of construction is the Duxon C-10 in which three double spaced beams are employed, bracing advantage of the full depth of the section, the middle beam being at the maximum deflection. Good loading on a wing of this type shows that there is actually no torsional deflection when the load is not supported with the beams.

Increasing Number of Wood Members in Wooden Airplanes

In early airplanes practically the only metal members and ribs of the power plant and outside were the wheels, tail, wire, and fittings. Most parts have gradually replaced wood, however, and at the present time a quite surprising number of parts are made of metal for the majority of parts even in the so-called wooden airplane. It is not at all unusual to find in the so-called wooden airplane the following parts made of metal: landing gear, engine members, tapered bulkheads, a few fuselage struts, tail post, tail shaft, tail surfaces, struts, or hinges, struts, wires, and fittings, practically the whole wooden members being the fuselage frame, the wing beams and the ribs.

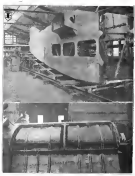
The use of the wooden steel tube for struts and wings when one of the decided advantages of the metal covering. The steel tube was usually riveted to the fuselage, first, because it was easily subjected to the purposes in which it was put and, second, because it was simply a standard product and could be easily obtained. The trend now is to particularly advantage for struts which are exposed to the air stream because the large volume of systems of the ribs and the high modulus of elasticity of steel is a great advantage in a narrow strut. It is quite generally believed that there is an advantage in using steel for long struts, even. The increased strength of the long strut is a function of the modulus of elasticity which is the same for all steels. This modulus, however, has not been supported by tests which show that the alloy steel tube has a higher strength strength



Interior of fuselage wing, with the upper surface riveted to the corrugated structure. The fuselage structure is attached to the fuselage structure shown in Fig. 3. The wing is carrying a speed not as used to be used as the ribs were. The ribs are now covered by a 75 in. chord wing with flattened ribs and riveted. The wings proved that they are of steel.

steel mild carbon steel in long struts. This is particularly true with this applied tubes which may also seem to be less when it is applied and is not as easily tested by load bending. For short struts, longer tubes and longer members there is no question of the superiority of alloy steel. For members which are extremely subjected to tension and compression, the aluminum struts of the wing of the fuselage, the steel tube is probably the only thing that has ever been used.

The fuselage tube is now available in the country and is well suited to use for struts where there is no woodwork



Engine-fuselage construction—front, the fuselage with a wing strut, below, the first tubes mounted in the wing.

construction in the fuselage. The diameter of the fuselage must be as large as that of a steel strut where a break must be placed on the thickness of the end to break against straining. Any increase in diameter means an increase in the radius of gyration, a higher allowable average stress and consequently a lighter strut.

Materials and Process Available

Almost any material or process which it is possible for science to produce may be obtained if the demand is great enough in the way of airplane development has been the first but except at extreme the demand for expensive materials of construction has been in quantities too small to make production profitable. The aircraft manufacturers who received special orders of steel and aluminum and who in their own minds have been producing, making and designing was generally considered to pay a very high price. In most cases he has had to beg the vendor to do business with him at any price. These facts have a number of consequences however who have considered that it was in their best interests to serve the aircraft trade. The result has been the same whether they believed in the value of the expense or whether they are in the service of the industry. The materials which might find a market in other lines of industry.

The steel wire and cable were among the few metal parts of the early airplane. The steel wire and cable were and still are furnished primarily by the John A. Roebling's Sons Co. of Trenton, N. J.

The American Steel and Wire Co. of Pittsburgh, Pa., is another producer of wire and cable.

The Washburn, Correll Foundry and Machine Co. of Washburn, Conn., has developed a process whereby titanium may be added on wire rods which results in a much smaller reduction in strength than is achieved with cold draws. The adding process results in a wire of the same size and the same as the wire of the fuselage in the fuselage, that can be obtained without heat treating.

The Stewart-Hartman Co. of Jersey City, N. J., have been producers in the development of aluminum wire in this



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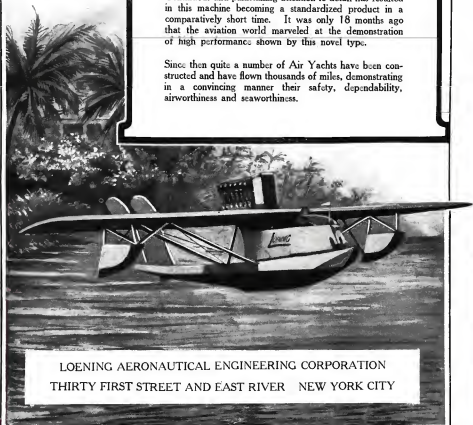
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